

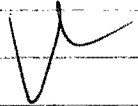


Ship Mon, 16/05

\*

# Work Order ID 69574


Thursday, May 12, 2011 11:20:01 AM

|                |                      |            |   |   |               |   |
|----------------|----------------------|------------|---|---|---------------|---|
| Item ID:       | D3675-6              | Accept     |  | Setup   | Start         |  |
| Revision ID:   |                      |            |   |   |               |   |
| Item Name:     | Sliding Door Bracket |            |   |   | Stop          |  |
| Start Date:    | 5/12/2011            | Start Qty: | 3.00  |  | Cust Item ID: |   |
| Required Date: | 5/16/2011            | Req'd Qty: | 3.00  |  | Customer:     |   |
| Reference:     |                      |            |   |   |               |   |

|            |               |   |       |            |       |     |       |   |
|------------|---------------|---|-------|------------|-------|-----|-------|---|
| Approvals: | Process Plan: |  | Date: | Tooling:   | Date: | Run | Start |  |
|            | QC:           |   | Date: | SPC (Y/N): | Date: |     | Stop  |  |


| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |  |  |  |  |  |  |  |  |
|----------|--------------|--|--|--|--|--|--|--|--|
| D3675    | RevD         |  |  |  |  |  |  |  |  |


|   |                        |      |  |  |  |  |  |  |  |
|---|------------------------|------|--|--|--|--|--|--|--|
| 100   |                        | 0.00 |  |  |  |  |  |  |  |
|  | FLOW WATER JET         |      |  |  |  |  |  |  |  |
| Waterjet  | Memo                   | 0.00 |  |  |  |  |  |  |  |
| FLOW CNC Waterjet   | 1-Cut as per Dwg D3675 |      |  |  |  |  |  |  |  |
| 304 . 040   | Dwg Rev: <u>D</u>      |      |  |  |  |  |  |  |  |
|   | Prog Rev: <u>0</u>     |      |  |  |  |  |  |  |  |
|   | 2-Deburr if necessary  |      |  |  |  |  |  |  |  |

B11-5-12

(6)

|   |   |      |  |  |  |  |  |  |  |
|---|---|------|--|--|--|--|--|--|--|
| 110   | QC2- Inspect parts off machine FAI/FAIB | 0.00 |  |  |  |  |  |  |  |
|  |   |      |  |  |  |  |  |  |  |
| QC  | Memo                                    | 0.00 |  |  |  |  |  |  |  |
| Quality Control   |   |      |  |  |  |  |  |  |  |

B11-5-12

|   |                                   |      |  |  |  |  |  |  |  |
|---|-----------------------------------|------|--|--|--|--|--|--|--|
| 120   | QC8- Inspect parts - second check | 0.00 |  |  |  |  |  |  |  |
|  |                                   |      |  |  |  |  |  |  |  |
| QC  | Memo                              | 0.00 |  |  |  |  |  |  |  |
| Quality Control   |                                   |      |  |  |  |  |  |  |  |

8 11/05/13

(6)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Work Order ID 69574



Page 2

Thursday, May 12, 2011 11:20:01 AM

Item ID: D3675-6

Accept



Setup Start



Revision ID:

Stop



Item Name: Sliding Door Bracket

Start Date: 5/12/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 5/16/2011 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

Form as per Dwg D3675 use DT9723

SB 11/05/13



140

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

8 11/05/13



-6

150

0.00



Grey Sandtex(Ref:4.3.5.6) per QS1005 4.3

Powdercoat

Memo

0.00

Powder Coating

START TIME:  
OVEN TEMPERATURE:  
FINISH TIME:

10:50  
3200F  
11:20

6X Ø m-l 11/05/13

M115128

**Work Order ID 69574**

Page 3

Thursday, May 12, 2011 11:20:01 AM

Item ID: D3675-6

Accept



Setup Start



Revision ID:

Stop



Item Name: Sliding Door Bracket

Start Date: 5/12/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 5/16/2011 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

| Sequence ID/<br>Work Center ID    | Operation<br>Description                                | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|-----------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 160<br><br>QC<br>Quality Control  | QC3- Inspect Part Finish<br><br>Memo                    | 0.00<br><br>0.00     |         |        |              |               |               | 11/5/13          | 61             |
| 170<br><br>Packaging<br>Packaging | Identify as per dwg & Stock Location<br><br>Memo        | 0.00<br><br>0.00     |         |        |              |               |               | 11/5/13          | 60             |
| 180<br><br>QC<br>Quality Control  | QC21- Final Inspection - Work Order Release<br><br>Memo | 0.00<br><br>0.00     |         |        |              |               |               | 11/5/16          | MF<br>11-05-13 |

# Picklist Print

Thursday, May 12, 2011 11:19:58 AM

Page 1

Work Order ID: 69574



Parent Item: D3675-6



Parent Item Name: Sliding Door Bracket


Start Date: 5/12/2011

Required Date: 5/16/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A 11.01.11 new issue DD verified by:EC IPP Rev C  
11.03.31 ECN 11-531 EC verified by:DD

| Component Item ID/<br>Item Name  | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M304S20GA<br> |                        | Purchased     | No          |                     |                  | 100             | sf                 | 86.7000        | 0.4092      | 1.292211     |               |                |        |

304/316 .040 Sheet



B11-5-12

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| MAT020          | 86.7           |                 |
| 116623          | 0.2            |                 |
| 117550          | 86.5           |                 |

117550

6

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

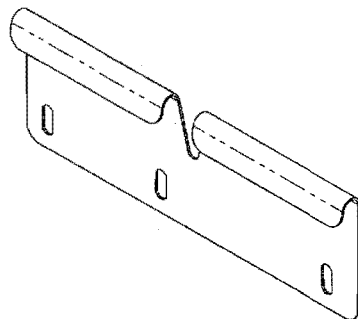
Q9574

## FIRST ARTICLE INSPECTION CHECKLIST

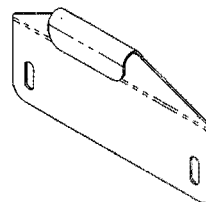
[illegible]

|                 |               |                       |
|-----------------|---------------|-----------------------|
| Measured by: RB | Audited by: S | Preliminary Approval: |
| Date: 11-5-12   | Date: 11/5/13 | Date:                 |

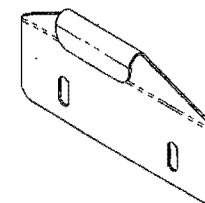
| Rev | Date     | Change                           | Revised by | Approved |
|-----|----------|----------------------------------|------------|----------|
| A   | 11.02.01 | New Issue                        | KJ         |          |
| B   | 11.04.06 | Dimensions updated per Dwg Rev D | KJ         |          |



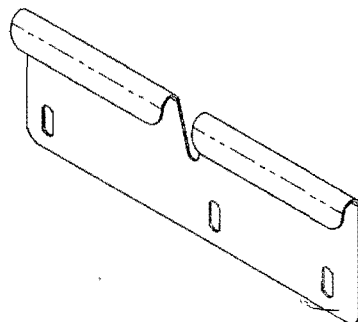
**D3675-5 SLIDING DOOR BRACKET**



**D3675-1 SLIDING DOOR BRACKET**



**D3675-3 SLIDING DOOR BRACKET**  
(HINGE PANEL MOD)



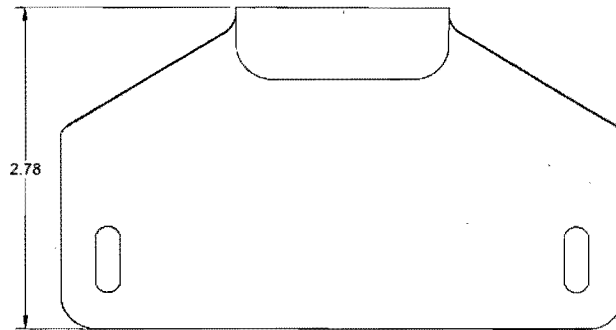
**D3675-6 SLIDING DOOR BRACKET**

**RELEASED**  
2011-03-31

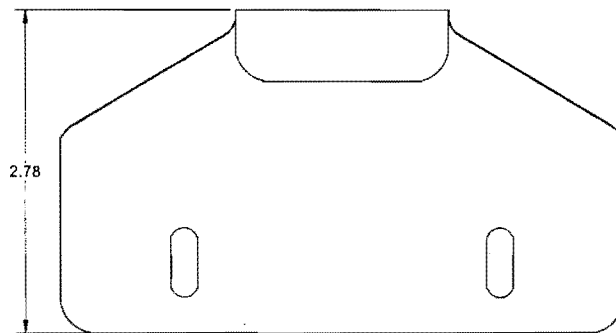
*09574*

|            |   |   |          |
|------------|---|---|----------|
| REV.       | DESCRIPTION   | BY  | DATE     |
| D          | RE-DESIGNED D3675-5/-6/-5F PER CUSTOMER FEEDBACK TO ELIMINATE BINDING OF DOOR ONCE BRACKETS ARE INSTALLED. REF. PART 11-79. | MB  | 11.03.21 |
| C          | ADD -5/-5F/-6 BRACKET   | MB  | 10.12.17 |
| B          | ADD -3 FOR HINGE PANEL MOD.   | AJS   | 08.11.03 |
| A          | NEW ISSUE   | AJS   | 08.03.27 |
| DESIGN     | AJS   | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA<br>DRAWING NO. <b>D3675</b> REV. D<br><b>SLIDING DOOR BRACKET</b> SHEET 1 OF 6<br><b>(COMPOSITE DOOR)</b> SCALE NTS<br><small>COPYRIGHT © 2008 BY DART AEROSPACE LTD<br/> THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> |          |
| DRAWN      | AJS   |   |          |
| CHECKED    | AJS   |   |          |
| MFG. APPR. | AS  |   |          |
| APPROVED   | AS  |   |          |
| DE APPR.   | AS  |   |          |
| DATE       | 11.03.21  |   |          |

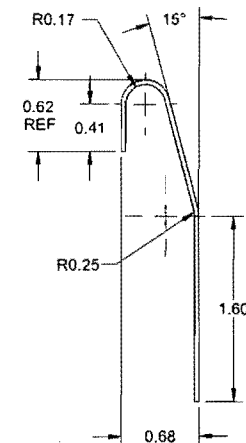
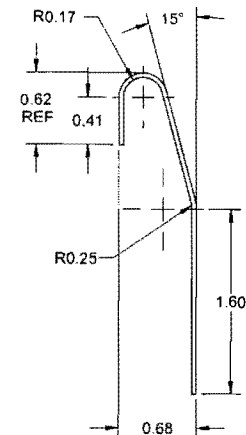




**D3675-1 SLIDING DOOR BRACKET**  
(MAKE FROM D3675-1F)



**D3675-3 SLIDING DOOR BRACKET**  
(MAKE FROM D3675-3F)  
(HINGE PANEL MOD)



**RELEASED**  
2011-03-31  
JH

**NOTES:**

- 1) MATERIAL: SEE SHEET 5
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3675-X" AND B/N "BXXXX" PER QSI 044 6.1
- 7) WEIGHT: 0.15 lbs EACH
- 8) THE D3675-1 SLIDING DOOR BRACKET IS A DERIVATIVE OF THE D3199-1 BRACKET.

69574

|            |          |                             |                      |
|------------|----------|-----------------------------|----------------------|
| DESIGN     | AJS      | <b>DART AEROSPACE LTD</b>   |                      |
| DRAWN      | AJS      | HAWKESBURY, ONTARIO, CANADA |                      |
| CHECKED    | AJS      | DRAWING NO.                 | REV. D               |
| MFG. APPR. | N        | D3675                       | SHEET 2 OF 6         |
| APPROVED   | AJS      | TITLE                       | SLIDING DOOR BRACKET |
| DE APPR.   | AJS      | (COMPOSITE DOOR)            | SCALE                |
| DATE       | 11.03.21 |                             | NTS                  |

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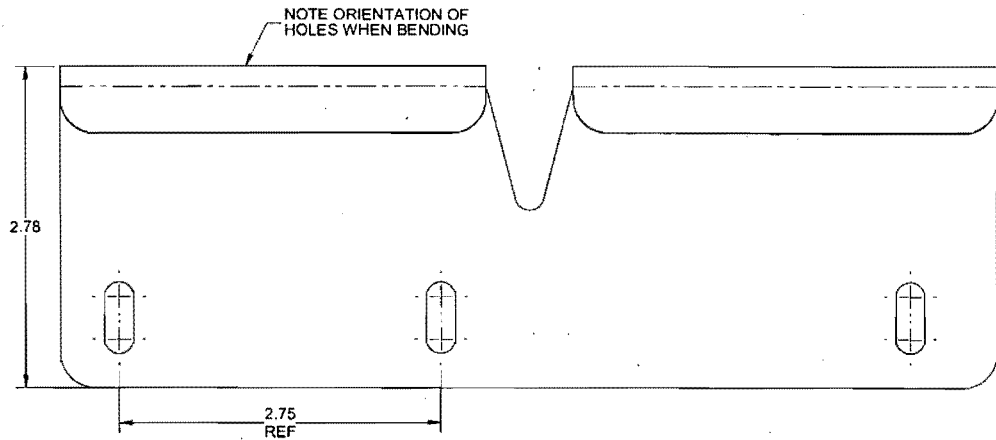
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D

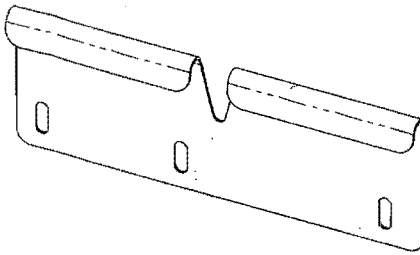
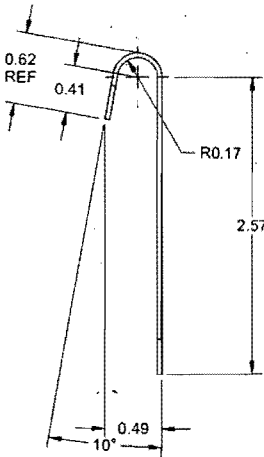
C

B

A



**D3675-5 SLIDING DOOR BRACKET**  
(MAKE FROM D3675-5F)



**RELEASED**  
2011-03-30

- NOTES:**
- 1) MATERIAL: SEE SHEET 6
  - 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3675-5" AND B/N "BXXXXX" PER QSI 044 6.1
  - 7) WEIGHT: 0.31 lbs EACH
  - 8) THE D3675-5 SLIDING DOOR BRACKET IS A DERIVATIVE OF THE D3199-3 BRACKET.

69574

|            |          |                             |                      |
|------------|----------|-----------------------------|----------------------|
| DESIGN     | 115      | <b>DART AEROSPACE LTD</b>   |                      |
| DRAWN      | 115      | HAWKESBURY, ONTARIO, CANADA |                      |
| CHECKED    | 115      | DRAWING NO.                 | REV. D               |
| MFG. APPR. | 115      | D3675                       | SHEET 3 OF 6         |
| APPROVED   | 115      | TITLE                       | SLIDING DOOR BRACKET |
| DE APPR.   | 115      | (COMPOSITE DOOR)            | SCALE                |
| DATE       | 11.03.21 |                             | NTS                  |

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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

D

D

C

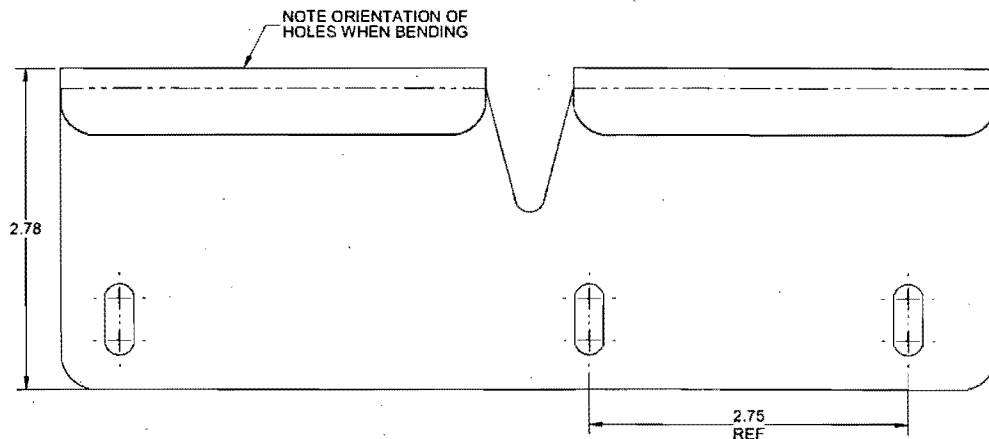
C

B

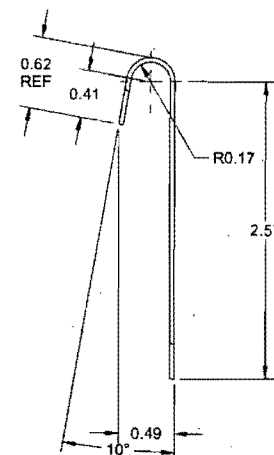
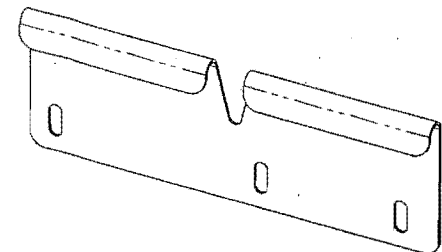
B

A

A



**D3675-6 SLIDING DOOR BRACKET**  
(MAKE FROM D3675-5F)



**RELEASED**  
2011-03-30

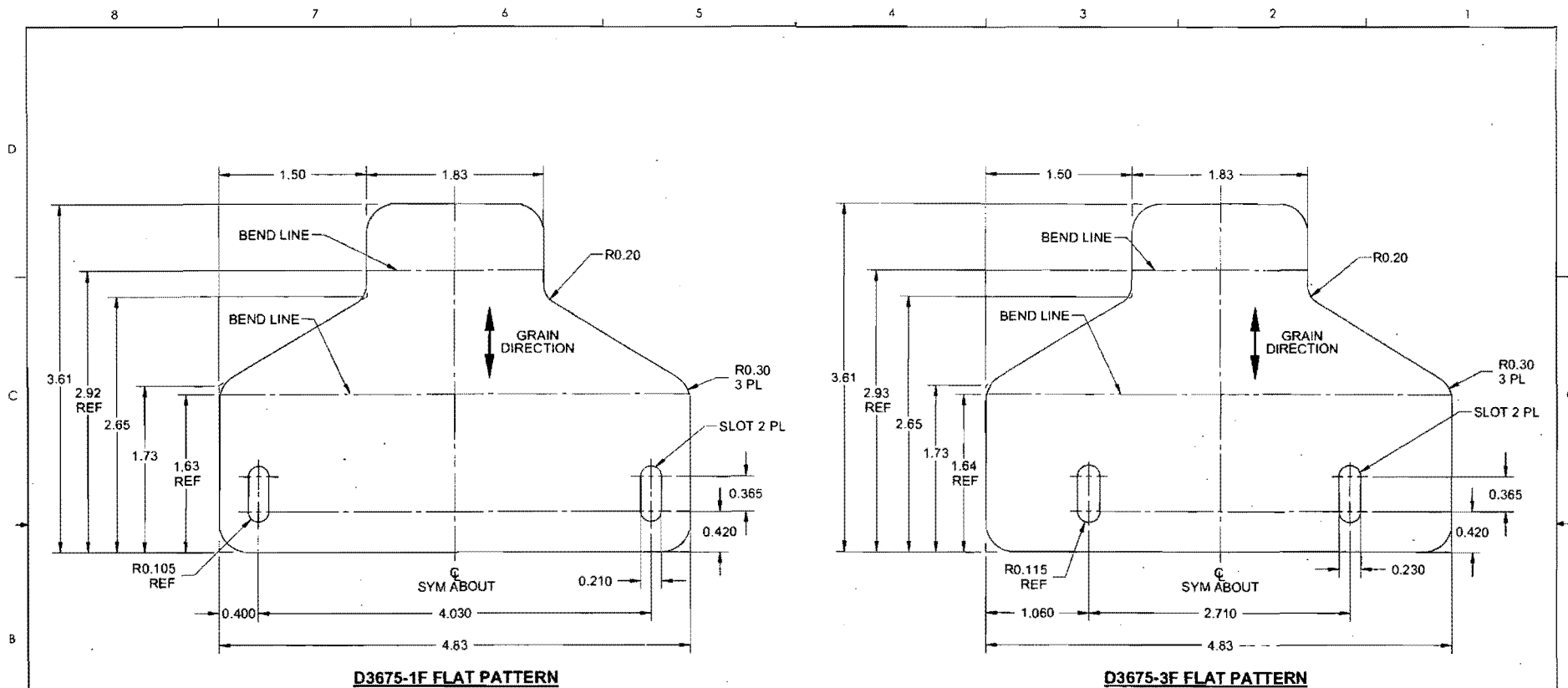
**NOTES:**

- 1) MATERIAL: SEE SHEET 6
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3675-6" AND B/N "BXXXXX" PER QSI 044 6.1
- 7) WEIGHT: 0.31 lbs EACH
- 8) THE D3675-6 SLIDING DOOR BRACKET IS A DERIVATIVE OF THE D3199-4 BRACKET.

69574

|            |          |   |           |
|------------|----------|---|-----------|
| DESIGN     | AS       | <b>DART AEROSPACE LTD</b>   |           |
| DRAWN      | AS       | HAWKESBURY, ONTARIO, CANADA   |           |
| CHECKED    | AS       | DRAWING NO. <b>D3675</b>  | REV. D    |
| MFG. APPR. | AS       | SHEET 4 OF 6  |           |
| APPROVED   | AS       | TITLE <b>SLIDING DOOR BRACKET (COMPOSITE DOOR)</b>  | SCALE NTS |
| DE APPR.   | AS       | COPYRIGHT © 2008 BY DART AEROSPACE LTD  |           |
| DATE       | 11.03.21 | THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. |           |

8 7 6 5 4 3 2 1



**D3675-1F FLAT PATTERN**

**D3675-3F FLAT PATTERN**

RELEASED  
2011-03-31

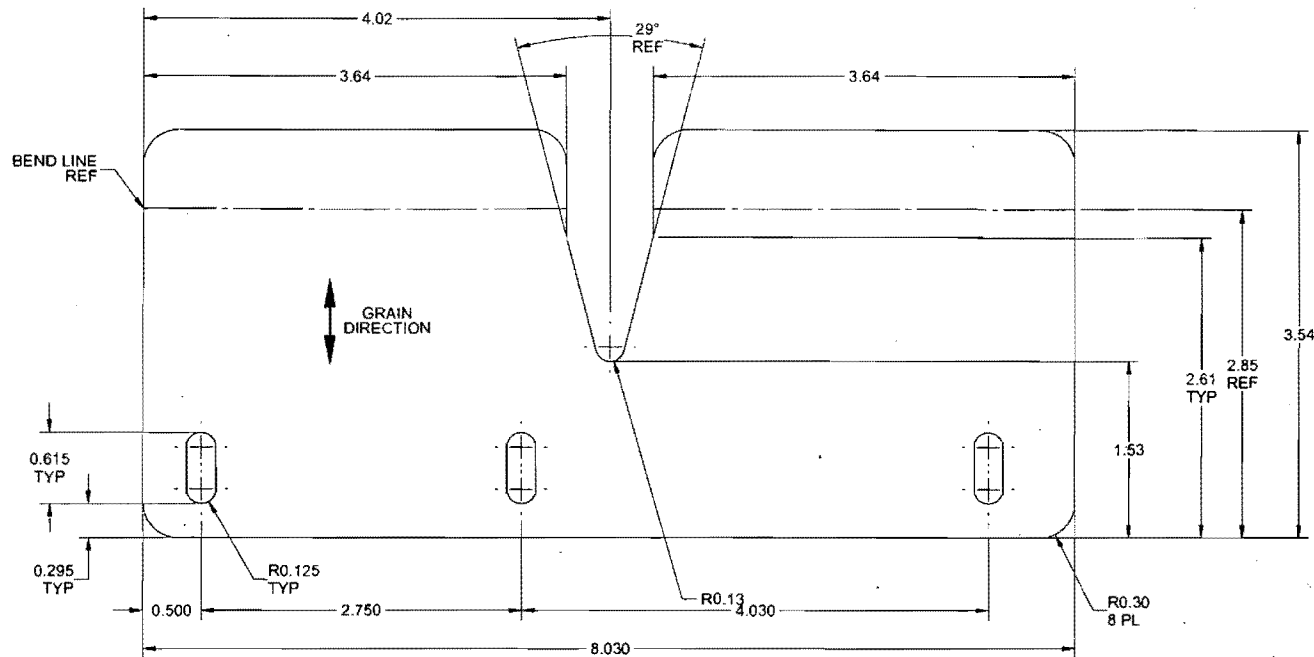
**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.040 THICK  
PER MIL-S-5059 (ANNEALED) OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240  
REF. DART SPEC M304S20GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.15 lbs EACH

69574

|            |          |                             |                      |
|------------|----------|-----------------------------|----------------------|
| DESIGN     | 715      | <b>DART AEROSPACE LTD</b>   |                      |
| DRAWN      | A        | HAWKESBURY, ONTARIO, CANADA |                      |
| CHECKED    | AIS      | DRAWING NO.                 | REV. D               |
| MFG. APPR. | N        | D3675                       | SHEET 5 OF 6         |
| APPROVED   | 12       | TITLE                       | SLIDING DOOR BRACKET |
| DE APPR.   | #        | (COMPOSITE DOOR)            | SCALE                |
| DATE       | 11.03.21 |                             | NTS                  |

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**D3675-5F FLAT PATTERN**

**RELEASED**  
2011-03-31

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.040 THICK  
PER MIL-S-5059 (ANNEALED) OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240  
REF. DART SPEC M304S20GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.67 lbs

69574

|            |          |                             |                      |
|------------|----------|-----------------------------|----------------------|
| DESIGN     | AJS      | <b>DART AEROSPACE LTD</b>   |                      |
| DRAWN      | B        | HAWKESBURY, ONTARIO, CANADA |                      |
| CHECKED    | AJS      | DRAWING NO.                 | REV. D               |
| MFG. APPR. | N        | D3675                       | SHEET 6 OF 6         |
| APPROVED   | 42       | TITLE                       | SLIDING DOOR BRACKET |
| DE APPR.   | 42       | (COMPOSITE DOOR)            | SCALE                |
| DATE       | 11.03.21 |                             | NTS                  |

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